

NON EUROCOPTER

Work Order ID 75234

75234

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October-19-11 3:17:08 PM

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step, Long RH
 Start Date: 19/10/2011 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/10/19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Document Control Photocopy bluefile and type labels as per PPP D350-591-312 CHG002
 NON EUROCOPTER

5 u/u/18

MLJ 11-11-14
 (4)

110
 110 Large Fab 0.00
 Large Fab Memo 0.00
 Large Fab 1-Bevel end for welding FWD ONLY

11.11.01

4/

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg
 D3272
 A/R Aluminum Rod 114514
 118735
 3-Grind End Plate flush

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	BEN/11/07	
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	0		

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Item ID: D350-591-312

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long RH

Start Date: 19/10/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

4 BR 11-11-1

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg.D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod **M114514**

6-Grind End Plate flush

7-Install last rivet as per Dwg.

4
11-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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4x0 ml 11/11/11
RH

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item Name: Heli-Access-Step, Long RH

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Start Date: 19/10/2011 Start Qty: 4.00

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Required Date: 07/11/2011 Req'd Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220 Powdercoat Powder Coating	Memo START TIME: 9:20 OVEN TEMPERATURE: 320°F FINISH TIME: 9:50	0.00							4X2 M 11/11/11 RH
230	Wing Walk as per dwg QSI005 4.4 Batch 18988	0.00							
230 HandFinish Hand Finishing	Memo	0.00							H. BK 11-11-11
240	QC3- Inspect Part Finish	0.00							
240 QC Quality Control	Memo	0.00							4RH p 20 11/11/11 COUNT MEASURE

W/O:		WORK ORDER CHANGES					
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Start Date: 19/10/2011 Start Qty: 4.00

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Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270									
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: _____								

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

11/11/22 
 MF
 11-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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October-19-11 3:17:12 PM

Work Order ID: 75234

75234

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011		Manufactured	No				Each	0.0000		4			
DSI 9410-011									**	B76454		10/11/17	
Step Modification													
D3272-1		Manufactured	No			110	Each	0.0000	1	4			
D3272-1									**			11.11.01	
Step													
D3067-1		Manufactured	No			110	Each	63.0000	1	4			
D3067-1									**			11.11.01	
End Plate													

Location

Loc Qty

Loc Code

WA

62

67582

2

73404

60

WA016

1

68214

1

D3219-1

Manufactured No

110

Each

130.0000

2

8

D3219-1

Plate

**

Location

Loc Qty

Loc Code

WA

130

73410

130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 75234

75234

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3066-1 Manufactured No

180

Each

48.0000

2

8

D3066-1

Spacer

**

11.11.08

Location

Loc Qty

Loc Code

WA

B75076

48

8

73409

48

MS20600-AD4W4

Purchased

No

180

Each

2,694.000

16

64

MS20600-AD4W4

Rivets

**

11.11.08

Location

Loc Qty

Loc Code

ST321

2689

116188

59

117364

253

117601

200

117885

195

118840

1982

WA018

5

116712

5

D3065-041

Manufactured

No

180

Each

0.0000

1

4

D3065-041

Step Leg Assembly Hi

D3067-1

Manufactured

No

180

Each

63.0000

1

4

D3067-1

End Plate

**

11.11.08

**

11.11.08

Location

Loc Qty

Loc Code

WA

B75468

62

4

67582

2

73404

60

WA016

1

68214

1

October-19-11 3:17:12 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75234

75234

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

AN3-35A
AN3-35A
Bolt

Purchased No 250 Each 103.0000

**

Location	Loc Qty	Loc Code
ST353	103	
117619	3	
117794	1	
118838	99	

D3235-1
D3235-1
Mounting Lug

Manufactured No 250 Each 136.0000

**

Location	Loc Qty	Loc Code
ST481	136	
71965	30	
73411	106	

D3278-041
D3278-041
Support Assembly

Manufactured No 250 Each 36.0000

**

Location	Loc Qty	Loc Code
ST481	36	
73107	36	

AN960JD416 NAS1149D0463J Purchased No 250 Each 0.0000
AN960.ID416

Washer
AN960JD516 NAS1149D0563J Purchased No 250 Each 0.0000

AN960.ID516
Washer

**

**

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

AN5-36A

Purchased

No

250

Each

115.0000

AN5-36A

Bolt

**

Location

Loc Qty

Loc Code

ST340

15

118838

15

ST341

100

118451

100

Manufactured

No

250

Each

58.0000

D2618

D2618

Bushing

**

Location

Loc Qty

Loc Code

ST019

58

73408

58

Manufactured

No

250

Each

183.0000

D2230-3

D2230-3

Lug

**

Location

Loc Qty

Loc Code

ST476

4

53881

4

ST480

179

70973

1

73396

178

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2856-400

Manufactured No

250 f

334.8845 1.2 4.8

D2856-400

Abraison Strip

**

SP

Location

Loc Qty

Loc Code

ST403

0.3149

68076

0.3149

ST409

334.5696

63735

0.6696

71164

117.9

~~73491~~

216

4.8

cut (2) D2856-400-720 as per dwg

MS21042I3

Purchased No

250 Each

9,994.000

2

1.8

MS21042I 3

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

994

117441

16

117885

87

118451

193

118927

698

ST516

6000

119017

6000

ST518

3000

119075

3000

8

AN4-13A*

Purchased No

250 Each

1,144.000

8

32

AN4-13A

Bolt

**

11/11/18 SP

Location

Loc Qty

Loc Code

ST357

1144

118078

590

~~118706~~

54

118838

500

32

W/O:		WORK ORDER CHANGES					
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Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

250

Each

2,546.000

MS21042I 5

Nut

Location

Loc Qty

Loc Code

ST300

1046

116105

5

116548

53

117441

110

117611

82

118179

496

118910

300

ST518

1500

119109

1500

MS21042L4

Purchased

No

250

Each

14,038.00

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

3038

117441

51

117601

537

117885

56

118451

1394

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

AN960.ID10

Washer

W/O:		WORK ORDER CHANGES					
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DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75234 *M.C.5*

11/10/19

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

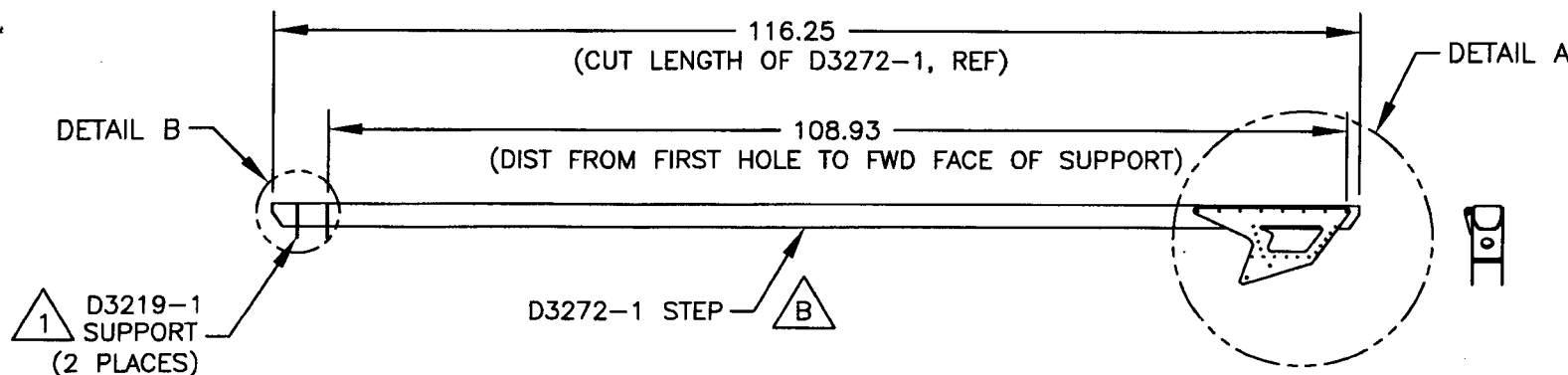
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

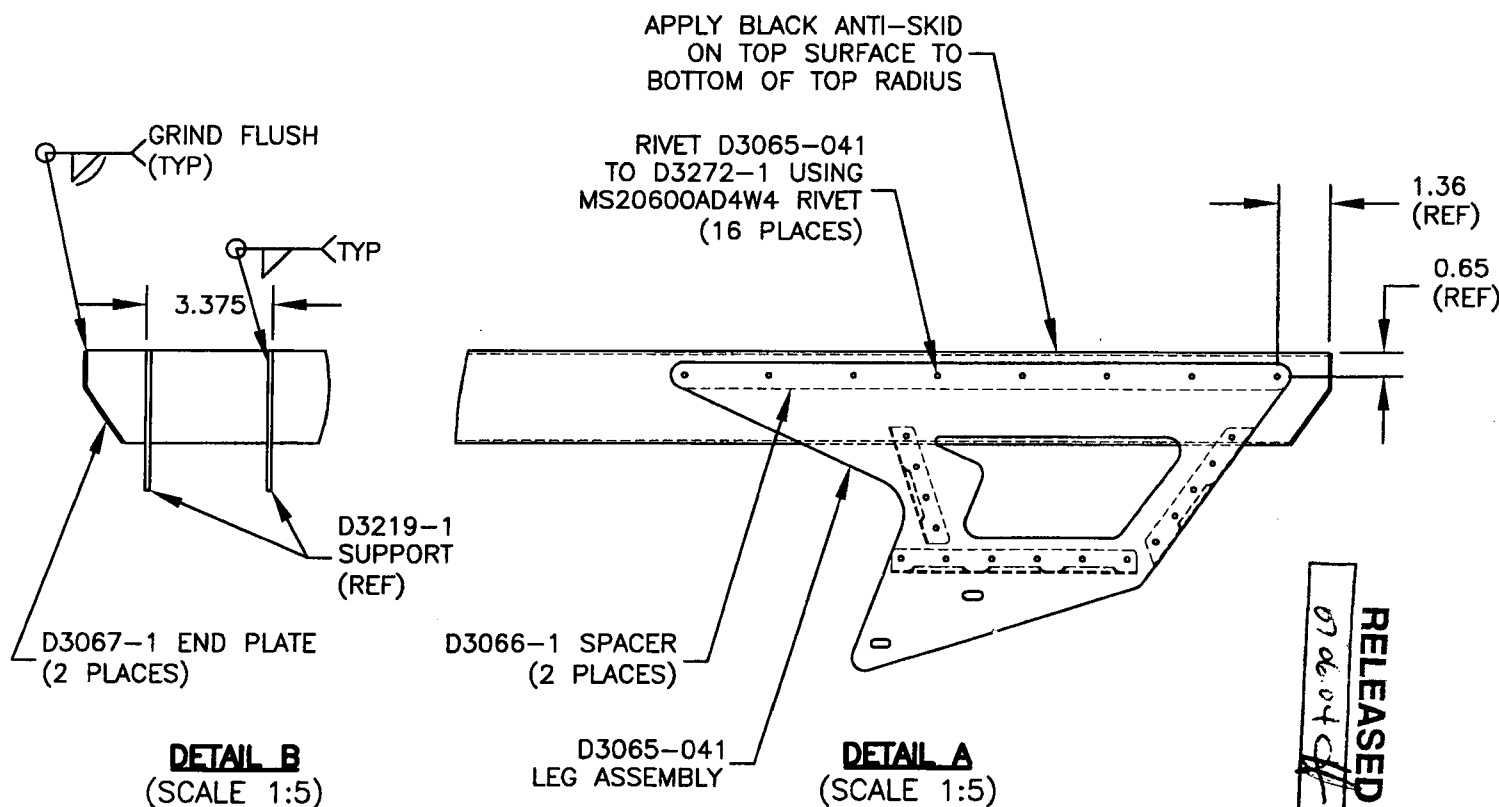
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75234

DART

D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	97	DRAWN BY	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	97	REV. B
DATE	07.05.18	TITLE	D3272	SHEET 2 OF 3
			STEP ASSEMBLY, HI LONG	SCALE 1:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

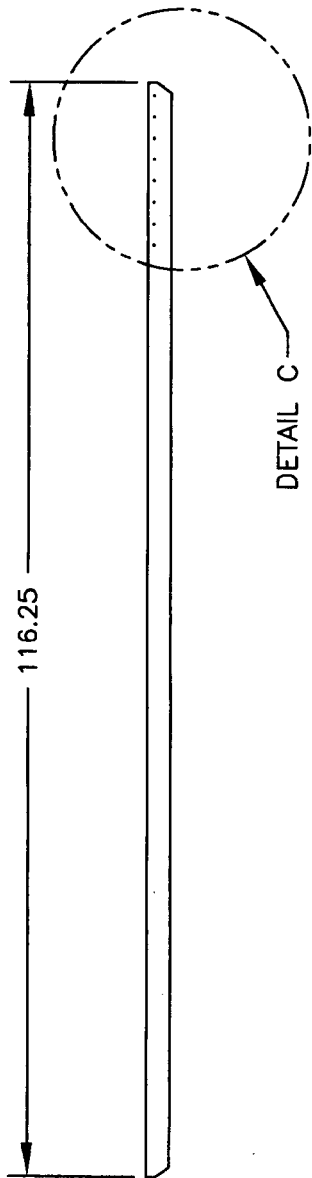
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

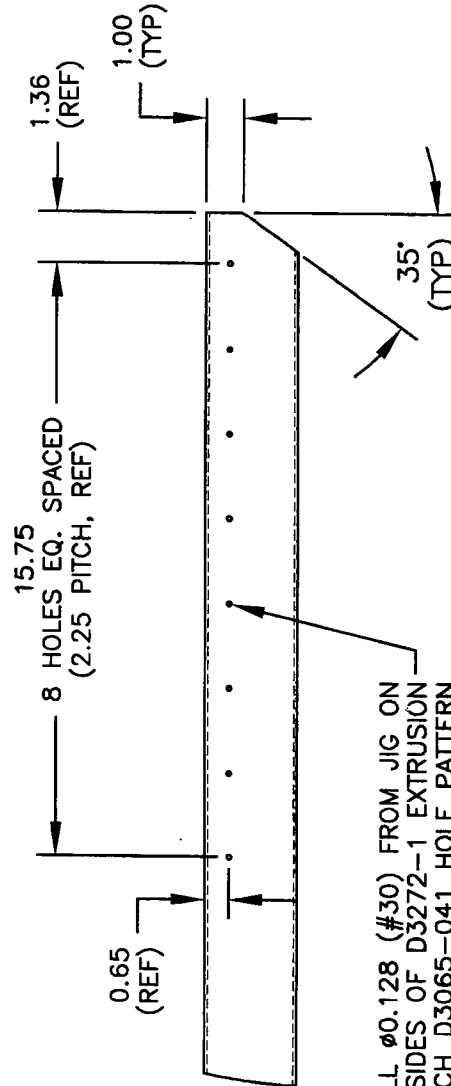
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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75234

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X							1	D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X						1	D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X					1	D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X				1	D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X			1	D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X		1	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X	1	D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.